



Dart Hawkesbury
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Tel (613) 632-5200

D4712-1
Job Sheet 167120



Part No: D4712-1

Job Qty: 60 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	60 Ea		11/9/17	0.00	0.00	Start Up Waterjet1	SC
100	Waterjet	60 pcs		11/9/17	0.00	3.87	Waterjet1	SC DAS
120	QC	60 pcs		11/9/17	0.00	0.00	QC8	38
130	Brake NC	60 pcs		11/9/17	0.04	2.30	Brake NC 2	SC DAS 9-88
140	QC	60 pcs		11/9/17	0.00	0.00	QC5	38
150	HandFinish	60 pcs		11/10/17	0.00	2.01	HandFinish1	2017-11-27
160	QC	60 pcs		11/10/17	0.00	0.00	QC7	38
170	Packaging	60 pcs		11/10/17	0.00	0.00	Packaging3	20
180	QC21-SA	60 Ea		11/10/17	0.00	0.00	QC21	DAS 21

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.040	5	72	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.630Inches + 0.008 - 0.001	0.638 0.629	Diameter	
2	Bracket	2.350Inches ± 0.030	2.380 2.320		
3	Bracket	1.300Inches ± 0.010	1.310 1.290		
4	Bracket	1.800Inches ± 0.030	1.830 1.770		
5	Bracket	0.900Inches ± 0.030	0.930 0.870		
6	Bracket	0.500Inches ± 0.030	0.530 0.470		
7	Bracket	1.200Inches ± 0.030	1.230 1.170		
8	Bracket	2.500Inches ± 0.030	2.530 2.470		
9	Bracket	3.800Inches ± 0.030	3.830 3.770		
10	Bracket	5.000Inches ± 0.030	5.030		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐			

Date : _____ Step #: _____ **B (QSI042) Approval**

Description Work Order Devt

Job No: 167120
Mfg Date: 11/11/17

Start up Operation
D4712-1

Change No:
Operation:
Revision:
PART NO:

Completed By

hand / Supervisor
Approval Verification

QA Coordinator
Approval



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Root Cause					
Environment ☐	No Re-verification ☐	Pressure/Fc ☐	Weld ☐	Part Incorrect ☐	ned Wrong
Design ☐	Operator ☐	Bending ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	e Dimensions
Doc/Data ☐	Offset/Setup ☐	Centre Not i ☐	Out of Sequence ☐	Part Moved ☐	Over/Under tolerance
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Off-set ☐	Drawing ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/I ☐	Mislabeled ☐	Finish ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Fit/Function ☐	Misread ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Misaligned/off center ☐	Turning Sequence ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐			
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐			
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : ☐			

			4.970	
11	Bracket	0.221Inches + 0.006 - 0.001	0.227 0.220	Diameter
12	Bracket	0.129Inches ± 0.010	0.139 0.119	
13	Bracket	6.000Inches ± 0.030	6.030 5.970	
14	Bracket	0.040Inches ± 0.010	0.050 0.030	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

